Work Order I June-25-13 11:49:3			*103	733*			G	PUSE	) <del>.</del>	Page 1
Revision ID: Item Name: Con Start Date: 6/23 Required Date: 7/03	/	* <b>4</b> * * <b>4</b> *	Accept	*N900 Cust Item II Customer:		100	)* s	etup Start Stop	1 74 .	S1* S2*
	ocess Plan: <u>Mし</u> て	Date: 13-010-25	Tooling: SPC (Y/N):		te:	-	R	tun Start Stop	~ <b>!V</b> !	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3867	В									
*100  *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET  Memo 1-Cut as pe Dwg Rev: Prog Rev: 2- Deburr i	r Dwg D3867  3 f necessary	0.00				_8_			Ac 13.09.04
*110 *110* QC Quality Control	QC2- Inspect parts off r	nachine FAI/FAIB	0.00				_8_			13.59.04
120 *120* QC Quality Control	QC8- Inspect parts - sec Memo	cond check	0.00 13 9	S			8			· <del></del>

DQA:			Date:										<b>T</b> DΔRT
QA Closed:			Date:			WORK ORDER NON-	·CC	NFO	RMANCE / UPD		ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	er:					·			a []		1	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	<del></del>
0						Rework	ļ		<b></b>	Crosstube		Water Jet	Engineering
Part f	۷O. –		<del></del>			Scrap			~ <del></del>	Small Fab	4	d. Eng. Coor.	Quality
NCR I	Ma					Use-as-is Suspected Unapproved	ļ	inern	noforming	Finishing	Kec/Stor	e/Packaging	Other
NCN I	۱U					suspected Onapproved			Large Fab C	omposite	J	Supplier	
Root		_			Desc	ription of work order update	lı	nitial	Action	_	Sign &		1
Cause		Date	Step	Qty		or non-conformance	Chi	ief Eng	Descripti	ion	Date	Verification	QC Inspector
Design													
Doc/Data	Ц												
Equip/Tooling													
Handling/Pre													
Material	Ш												
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Offset/Setup	Ц												
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Transport			<b>1</b> 1	j									
Unapproved	Ll.		<u> </u>				L			<del></del>			
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Landi					_	General				_ <del>-</del>	1		<b>-</b> 7
	—	Bending	_		<b> </b> _	Bend	-		rogram	<u> </u>	Outside Dime	<b>├</b>	Pressure/Forced
	${f H}$		ot Concer	itric	$\vdash$	BOM/Route	$\vdash$	Grain		<u> </u>	Over/Under	<b>├</b>	Set-up
	$\vdash$	cracks			<u> </u>	Broken/Damage/Defect		Hardwa			Part Incorrec	<del>-</del> -	Temperature/Cure
	<b>├</b>	-	rk/Ripple	/Wave	-	Burrs	$\vdash$	-	on Incomplete/Unqua	<u> </u>	Part Lost/Mi	ssing	Weld
	$\boldsymbol{\vdash}$	Cuffs			_	Contamination	_		ions Incomplete/Uncl	ear	Part Moved	<u> </u>	Wrong Stock Pulled
,	⊢	Crushing			<b> </b>	Countersink			ned/off center	<u> </u>	Positioned W		<b>7</b> .
	<b>⊢</b> ⊣	Heat Trea			<u> </u>	Cut Too Short	$\overline{}$	Mislabe			Power Loss/S	Surge	Other
			n Strip in	Tube		Drawing	-	Misread	}				
	${f -}$	Marks/Ch			<u> </u>	Drill Holes	$\boldsymbol{\vdash}$	Off-set					
		-	equence		<u> </u>	Finish	—		Calibration				
			Fit/Function		Out of Sequence								

Work Orde June-25-13 11:4				*1	ივ7	33*							Page 2
Item ID: Revision ID: Item Name:	D3867-1	Plate		Accept	*	N900	<b>040</b>	100	)*	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date: Reference:	6/27/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*			Cust Item I Customer:	D:						
Approvals:		Plan:		_ Tooling: _ SPC (Y/N	):	<del></del>	ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 130 *120* HandFinish Hand Finishing	D	Operation Description Chemical Conversion Co	oat per QS1005 4.1	Set Up. Run He 0.00		Tool ID	Tool#	Plan Code	Accep Qty	Qt	y	Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC7-Inspect Chemical (	Conversion Coat	0.00	DAS 27 9-89 B. J. S				8				<del>- ;</del> -
150 *150* Packaging			lock Location( <del>7</del> x)5T0						<u>8</u> >	· \$	200	13-09	-5

Packaging

DQA:	Date:					- ····································									
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	w	ork Order up	odate only	_ <del>-</del>	AEROSPACE	
						DISPOSITION			AGAINST		PARTMENT	· · · · · · · · · · · · · · · · · · ·			
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						Rework	l		Skid-tube Crosstube	_		Water Jet	∟'	Engineering	
Part N	io					Scrap		Machining Small Fab			-1	d. Eng. Coor.		Quality	
						Use-as-is	1 1	Therr	noforming Finishing	_	Rec/Stor	re/Packaging	-	Other	
NCR N	No				-	Suspected Unapproved			Large Fab Composite	<u> </u>	J	Supplier	<b>ن</b> ــــ		
Root					Descr	iption of work order update		Initial	Action		Sign &		-		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	n _	QC inspector	
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	Cra		<b>*</b>		<u> </u>	Broken/Damage/Defect		Hardwa		_	Part Incorred		<b> </b>	Temperature/Cure	
-	$\blacksquare$	Crimp/Kink/Ripple/Wave Burrs			<u> </u>	1	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	ssing	$\vdash$	Weld			
	Cuf					Contamination	<u> </u>	4	tions Incomplete/Unclear	-	Part Moved		لـــا	Wrong Stock Pulled	
	-	shing				Countersink	-	1	gned/off center	<u> </u>	Positioned V			 	
	<b>⊢–</b>	at Treat			-	Cut Too Short	_	Mislabe			Power Loss/	Surge	لب	Other	
	<b>—</b>		Strip in	lube	<u> </u>	Drawing	<u> </u>	Misrea							
	$\vdash$	rks/Cha				Drill Holes	-	Off-set				<b>-</b>	_		
	_		quence		-	Finish Fit/Function		ł	Calibration						
	1///1	MOLTANIC	ct in Tub	۵	1	I FIT / FILINCTION	1	Mout of 9	COLLORCO						

Work Order ID 103733 \*103733\* Page 3 June-25-13 11:49:39 AM \*N900040100\* Item ID: D3867-1 Accept Setup Start **Revision 1D:** Stop Item Name: Connector Plate Start Qty: 4.00 **Start Date:** 6/27/13 Cust Item 1D: Required Date: 7/01/13 Req'd Qty: 4.00 **Customer:** Reference: Run Tooling: Date: Process Plan: Date: Approvals: Stop SPC (Y/N): Date: Date: Tool ID Tool # Plan Reject Reject Insp. Set Up/ Sequence ID/ Operation Accept Qty Qty Stamp, Number Work Center ID Description Run Hours Code QC21- Final Inspection - Work Order Release 0.00 160 \*160\* 0.00 QC

Memo

Quality Control

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DQA:	Date:					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFOI	RMANCE / UPE		Vork Order u	pdate only	AEROSPAC	E	
Work Orde						DISPOSITION				AGAINST [	EPARTMENT	/PROCESS	<u> </u>		
WOOK OTO					-	Rework	ì		Skid-tube	Crosstube	7	Water Jet	Engineering	1	
Part N	No.					Scrap	1		Machining	Small Fab	Prod. Eng. Coo		Quality	1	
,					-	Use-as-is			noforming	Finishing	<del></del> -	re/Packaging	Other		
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	$\vdash$	re Not C	oncen	tric		BOM/Route	<u> </u>	Grain		ļ.	Over/Under	<u> </u>	Set-up		
	Crac				<u> </u>	Broken/Damage/Defect	匚	Hardwa		_	Part Incorre	<b>—</b>	Temperature/Cure	!	
	$\vdash$	ip/Kink/f	Ripple/	/Wave	<u> </u>	Burrs	L_		ion Incomplete/Unqu		Part Lost/M		Weld		
	Cuff				-	Contamination	╙	4	ions Incomplete/Unc	lear	Part Moved	_	Wrong Stock Pulled	t	
i	_	hing			-	Countersink	-	1	ned/off center		Positioned \		$\neg$		
	$oldsymbol{oldsymbol{eta}}$	t Treat				Cut Too Short	_	Mislabe		L	Power Loss,	'Surge	Other		
	<b>├</b> ─┤	ection St	· ·	Tube		Drawing	$ldsymbol{ld}}}}}}$	Misread	d			·	<u> </u>		
	<del></del>	ks/Chatt				Drill Holes		Off-set							
	_	ing Sequ			<b>—</b>	Finish	<u> </u>	i	Calibration						
	Wave/Twist in Tube			e	1 1	Fit/Function	1	Out of 9	Secuence						

Page 1

Work Order ID:

103733

Parent Item:

D3867-1

Parent Item Name:

Connector Plate

Start Date: 6/27/13

Required Date: 7/01/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 09-01-09 new issue DD verifyed by:EC DWG REV B DD VERF:JLM

IPP REV:B 13.01.15 AS PER

	DWG KEV.B DU	VERT.JLIVI											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	632,9000	0.17	<del>-0.713789</del> 0		£ 1:	3.09.0
	•			<b>Location</b>		Loc Oty	<u>Lo</u>	c Code					
				MAT021		632.9							
Sh	<b>D</b>			123	135	15							
~~	17			123	1137	10							
13	9,4			123	1293	10				<del>-</del>			
, –	• • •			123	483	256.6						41	
				m1:	25822	67.3							
				m1:	26115	274			12	6115 -	<del>-&gt;</del> ∙€	<del></del>	

DQA:		_ Date:												TAART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		Wo	ork Order ug	odate only		AEROSPACE
					DISPOSITION						PARTMENT			<u> </u>
Work Orde	er:				<del>,</del> -	1			_	_				, , ,
Part N	lo				Rework Scrap	4		Skid-tube Crosstul  Machining Small Fi			Water Jet Prod. Eng. Coor.			Engineering Quality
NCR N	lo			_	Use-as-is Suspected Unapproved		Therr	Thermoforming Finishin  Large Fab Composi		- <del></del>		ore/Packaging Supplier		Other
Root		<u> </u>		Desci	ription of work order update		nitial	Actio	on	Ī	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	า	QC Inspector
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Unapproved										ı				
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Landir	ng Gear				General								·	
	Bending				Bend		Folio/F	Program	[		Outside Dim	ensions		Pressure/Forced
	Centre I	Not Conce	ntric		BOM/Route		Grain		[		Over/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct		Temperature/Cure
	Crimp/k	ink/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear		Part Moved			Wrong Stock Pulled
	<b>1−</b> -1		Countersink		Misalig	ned/off center	[		Positioned V	Vrong		•		
	Heat Tre	eat			Cut Too Short		Mislabe	eled	ľ		Power Loss/	Surge		Other
	Inspection Strip in Tube Drawing		Drawing		Misread	<u>i</u>	_			<b>-</b>	_	· <u> </u>		
	Marks/0	hatter			Drill Holes		Off-set			-				
	Turning	Sequence			Finish		Out of (	Calibration		-				
	Wave/Twist in Tube			Fit/Function		Out of Sequence								

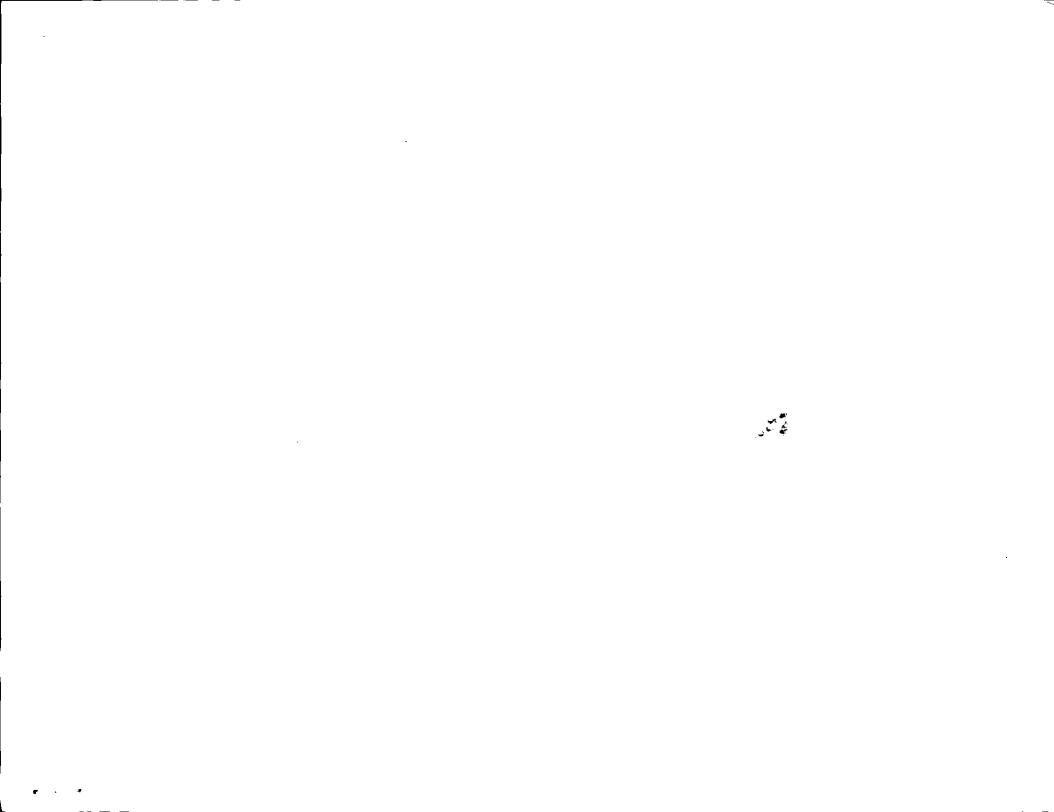
DART AEROSPACE LTD	Work Order:	103 733
Description: Connector Plate	Part Number:	D3867-1
Inspection Dwg: D3867 Rev: B		Page 1 of 1

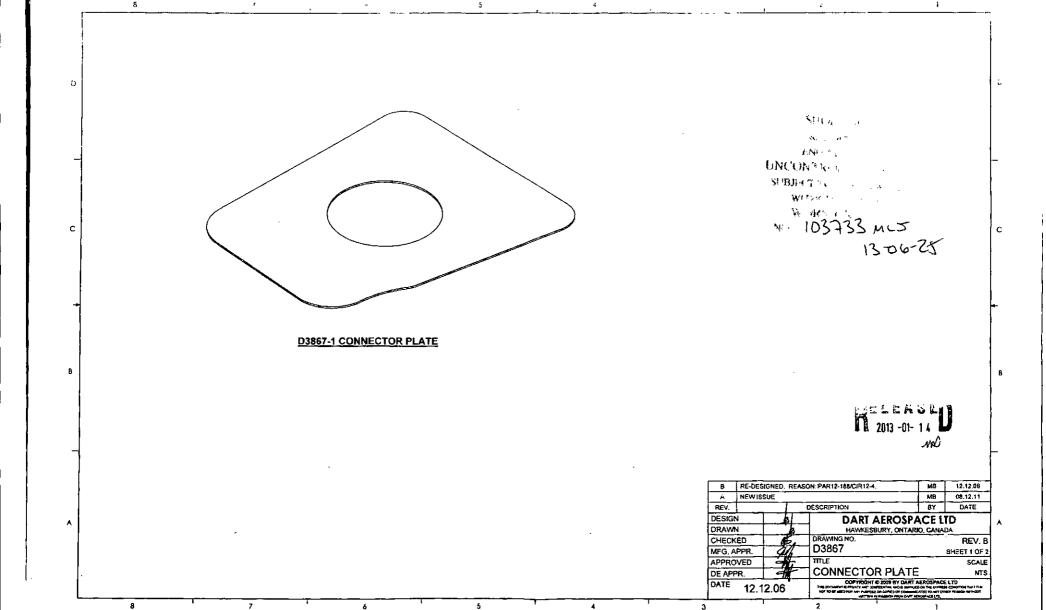
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø2.00	+0.012/-0.001	2.00	-		>	JKM- OI
0.032	+/-0.010	,032			<b>&gt;</b>	
5.37	+/-0.030	5.36	-		7	
2.52	+/-0.010	2.52	_		>	
4.62	+/-0.030	4.62	-		>	
R0.75	+/-0.030	.75			RG	

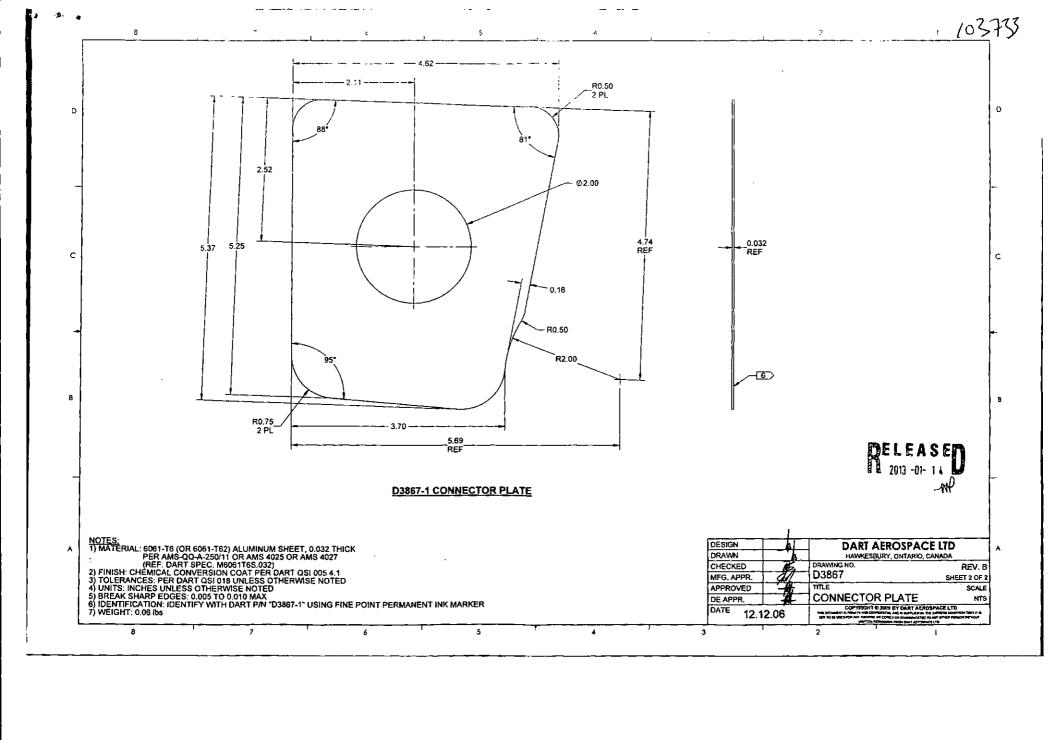
Measured by: Ae	Audited by: 27	Pretiminary Approval:
Date: 13.09.04	Date: 13 9 S	Date:

Rev	Date	Change	Revised b	y	Approved
Α	09.05.20	New Issue	KJ L	$\Delta$ _	
В	13.02.27	Dimensions updated per Dwg Rev B	KJ Q	<u> </u>	<u> </u>
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